Work Orde March-12-13 1:		410		*984	410	*						Page 1
Item ID: Revision ID: Item Name:	D3255-041 Access Panel A	Assembly	A	Accept	*N	900	<b>040</b>	100	)* s	etup Star Stop	171	S1* S2*
Start Date: Required Date: Reference:	3/11/13 3/22/13	Start Qty: 3.00 Req'd Qty: 3.00	*/** 4	<b>/</b>		ust Item II ustomer:	D:	, .				i i
Approvals:	Process Pla	n: " MLJ	Date: 13-03-13	Tooling:		Da	ıte:	- 	R	tun Star	1/1	R1*
	QC:		Date:	SPC (Y/N):		Da	ite:			Stop	` *N	R2*
Sequence ID/ Work Center II	<b>D</b>	Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3255	Rev	В										13-04
*100 *100* Large Fab Large Fab		Large Fab  Memo 1-Weld as p Batch:	per Dwg D3255 ***purge w		θD	,			4			
*110 *11 <b>0</b> *		QC10- Inspect visual pe	er QS1004- ground welds	0.00					(4)	13-04	1-19	DAS
QC		Memo		0.00							\ <u> </u>	. 8.89
Quality Control												
120		QC5- Inspect part comp	eleteness to step on W/O	0.00								MA'O.
*120* QC Quality Control		Memo		0.00					<u> </u>	13.04-19	9	DAG 909

							•					DQA:	Date:	
NCR: Y	'es	/ No					WORK ORDER NON-O	O	NFORI	MANCE / UP	DATE	QA Closed:	Date:	
						7						QA Closed:	. Date:	
Work Orde	r:					ļ	DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	-		<del></del>			Ì	Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					1	Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				•		1	Use-as-is	]	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo						Work Order Update	]		Large Fab	Composite		Supplier	
Root	_			· T	Dasc	rin	tion of work order update	П	nitial	۸۵	tion	Sign &		· · ·
Cause	İ	Date	Step	Qty	Desc		r Non-conformance		ief Eng		ription	Date	Verification	QC Inspector
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etup									:					
Other														
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upplier	_												٠	
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Landir T	_				Г	_	General	_	۱		_	٦ ، ١	Γ	1
~ <sub>2</sub> ,.	_	Bending			.,	-	Bend	-	Grain		<u> -</u>	Ovalized		Pressure/Forced
éc		Centre No	t Concer	itric to C	)/5	_	BOM/Route		Hardwa			Over/Under	<del></del>	Temperature/Ćure
· ,	_	Cracks				_	Broken/Damaged	$\vdash$	1	on Incomplete	 	Part Incorre	<del></del>	Weld
		Crushed/(	_rimpea		-		Burrs	-	Mainte	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Ì		Cuffs Heat Trea	+		. }	-	Contamination  Countersink	$\vdash$	Mislabe		-	Positioned V	Vrong	
		Inspection		Tuho	}		Cut Too Short	$\vdash$	Misread		F	Power Loss/		Other
	-	Ripples in		iube	-	-	Drill Holes	$\vdash$	Offset	•	L.	7, ower 1033/	Juige	Journel
	_	Torque W		ytrusion	, <b> </b>	-	Drawing		4	Calibration		<del></del>		·
	$\dashv$	Turning S			· }		Finish	-	1	Sequence		1		

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Work Ord		3410						Page	2			
Item ID: Revision ID: Item Name:	D3255-041 Access Panel	Assembly		Accept	*N900040	<b>1100</b>	)*	Setup	Start Stop	ıu.	S1*	
Start Date: Required Date: Reference:	3/11/13 : 3/22/13	Start Qty: 3.00 Req'd Qty: 3.00	*7*	<b>/</b>	Cust Item ID: Customer:							
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	Date:			Run	Start Stop	"  7	マ1* マク*	
Sequence ID/ Work Center I  130 *130* Powdercoat Powder Coating		Operation Description Grey Sandtex(Ref:4.3.5.6  Memo START TIMI	8,30	Set Up/ Run Hours 0.00  0.00  OVEN TEMPERATURE:	Tool ID Tool	# Plan Code	Accep Qty	t Re	•	Reject Number	Insp. Stamp	122
140 *140* QC Quality Control	-	QC3- Inspect Part Finish  Memo		0.00			4	L		<u>I</u>	13/0	ul z

0.00

0.00

1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg D3255A/R 736 DOW CORNING ADHESIVE Batch: M 2 2 3-(6

150

\*150\* Small Fab

Small Fab

Small Fab

											DQA:	Dat	e:	
NCR: Y	es	/ No				WORK ORDER NON-O	100	<b>NFORM</b>	MANCE / UPDATE		•	!		_
											QA Closed:	Dat	e:	_
Work Orde	r.					DISPOSITION			AGA	NINST DE	PARTMENT	/PROCESS		
VOIR OIGE	٠			<u> </u>		Rework	1 .		Skid-tube Cross	stube	]	Water Jet	Engineering	
Part N	0.					Scrap	1		<b>—</b>	ll Fab	Pro	d. Eng. Coor.	Quality	
	_				<del></del>	Use-as-is			~ <b>—</b>	shing	Rec/Stor	e/Packaging	Other	
NCR N	lo			<del></del>	···	Work Order Update	J		Large Fab Comp	osite	}	Supplier		
Root	<u> </u>	1			Descri	ption of work order update	<u>_</u> T 1	nitial	Action		Sign &			_
Cause		Date	Step	Qty		or Non-conformance		ief Eng	Description		Date	Verification	QC Inspector	
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rocess														
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Landir	ng G	ear	- · · · · - ·			General	_	-			j	-		
	1	Bending			<u> </u>	Bend		Grain		<u> </u>	Ovalized		Pressure/Forced	Ì
	(	Centre No	t Concer	ntric to (	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld	
		Crushed/C	Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled	ĺ
		Cuffs				Contamination		Mainte	nance		Part Moved			
		Heat Treat	t			Countersink		Mislabe	led	L	Positioned V	_		
		Inspection	Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other	
		Ripples in	Bend			Drill Holes		Offset						_
		Torque W	aves in E	xtrusio	n L	Drawing	L	Out of C	Calibration					_
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	[·	Wave/Twi	ist in Tub	oe -		Folio	1	Outside	Dimensions		İ			

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Work Ord March-12-13 1		410		*984				Page			
Item ID: Revision ID: Item Name:	D3255-041 Access Panel	Assembly		Accept	*N900	<b>040</b>	100	)* ፡	Setup Star	IV	S1* S2*
Start Date: Required Date Reference:	3/11/13 :: 3/22/13	Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*		Cust Item I Customer:	D:					
Approvals:		an:		Tooling: SPC (Y/N):		ate:		I	Run Stai Sto	I <i>N</i>	R1* R2*
Sequence ID/ Work Center I 160 *160* QC Quality Control	I <b>D</b>	Operation Description QC5- Inspect part comp	leteness to step on W/O	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Packaging		Identify as per dwg & St  Memo	SH76	0.00					(3/9)	/29-	-(4)

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

Packaging

\*180\*

Quality Control

180

[13/7/29 (4)

13/5/6 9

MF

13-4-29

	.,	,	
NCR:	Yes	/	No

Date:

NCR: Y	es / No				WORK ORDER NON-C	ONFO	PRIMANCE / UF	PDATE	QA Closed:	Date	
Work Orde	<del>.</del>				DISPOSITION			AGAINST D	EPARTMENT,	/PROCESS	
Part N				,	Rework Scrap		Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor	Engineering Quality
NCR N	o				Use-as-is Work Order Update	Th	ermoforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root		<u> </u>		Descri	ption of work order update	Initia	I Ad	ction	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief E	ng Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling	_										
Operator										·	
Material		·									
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Other											
Process						ĺ					
Supplier										•	
Training		ĺ									
Unapproved		<u> </u>				<u> </u>			<u> </u>		
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Landin	g Gear			_	General				٦		٦, ,
ļ	Bending				Bend	Gra		<u> </u>	Ovalized	<b>-</b>	Pressure/Forced
	Centre No	ot Conce	ntric to (	<sup>D/S</sup>	BOM/Route	$\vdash$	dware	ļ	Over/Under	. —	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged		ection Incomplete		Part Incorre	·	Weld
.	Crushed/	Crimped	•		Burrs	<b></b>	ructions Incomplete,	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
-	Cuffs			<u></u>	Contamination	$\vdash$	intenance	<u> </u>	Part Moved		
	Heat Trea			<u> </u>	Countersink	_	abeled	<u> </u>	Positioned V		الم
·	Inspectio		Tube	<u> </u>	Cut Too Short	$\vdash$	read	Ĺ	Power Loss/	Surge	Other
	Ripples ir			$oxedsymbol{oxed}$	Drill Holes	Offs					•
1	Torque V			ր  _	Drawing		of Calibration				
ļ	Turning S	-		L	Finish	<b>⊢</b> ⊣	of Sequence				
1	Wave/Tw	vist in Tul	oe	• 1	Folio	Out	side Dimensions				

Page 1

Work Order ID:

98410

Parent Item:

D3255-041

Parent Item Name:

Access Panel Assembly

**Start Date:** 3/1.1/13

Required Date: 3/22/13

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-1		Manufactured	No			100	Each	2.0000	1	3	w		12-0
Panel									e. 25 Y				13=04
	•			Location	A 7.7	Loc Qty	<u>Lo</u>	c Code	C~~	//٦			. ,
				WA002 YS	(510)	2				<del>/                                    </del>			
				7219	91	2							
3255-3		Manufactured	No			150	Each	4.0000	1	3			13-0
ар									33 THE				
				Location ()	0222	Loc Qty	<u>Lo</u>	c Code					
				78	1112	2				7 1			1
				759	69	. 2				<del></del>	•		
•		•		WA002 832	0.1	2							•
2255 5			No	832	01 .	100	Each	4.0000	1	3		_	. 2
3255-5 asket		Manufactured	NO			100	Lacii	4.0000		3			_/3/0
asket				<u>Location</u>		Loc Qty	Lo	c Code					;
						Luc Qty	<u>1.0</u>	<u>c coue</u>					
				GA 721	18	. 1			-				1
		•		750		1							!
				961		2							i
	•	•		6	B 9836	. ~			V				

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-	COI	NFOR	MANCE / UPDATE		QA Closed:	Date:	
			· <del>- · ·</del>		DISPOSITION			AGAINS		ARTMENT		
Work Orde	er:				DISPOSITION	_		AGAINS		ANTIVICIAL	/PROCE33	
Part N					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Crosstub Machining Small Fa noforming Finishin Large Fab Composit	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root		T		Descri	iption of work order update	T	nitial	Action	[	Sign &		
Cause	Date	Step	Qty		or Non-conformance	1	ief Eng	Description		Date	Verification	QC Inspector
oc/Data quip/Tooling Operator Material etup Other Process supplier Taining												
						FAUL	T CATE	GORY				
Landi	ng Gear				General	_	1		_		_	ا .
	Bending Centre N Cracks Crushed, Cuffs	'Crimped		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination		Instruct Mainte	ion Incomplete ions Incomplete/Unclear enance		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	essing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Heat Tre				Countersink	-	Mislabe			Positioned V		7
	Inspection		Tube	<u> </u>	Cut Too Short	Misread Power Loss/Surge Other			Other			
	Ripples i			<u> </u>	Drill Holes	-	Offset					
		Vaves in I		n	Drawing	<u> </u>	1	Calibration				
	Turning	Sequence	1	I	Finish	1	Out of 9	Sequence				

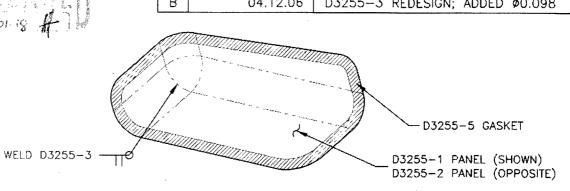
Outside Dimensions

Wave/Twist in Tube

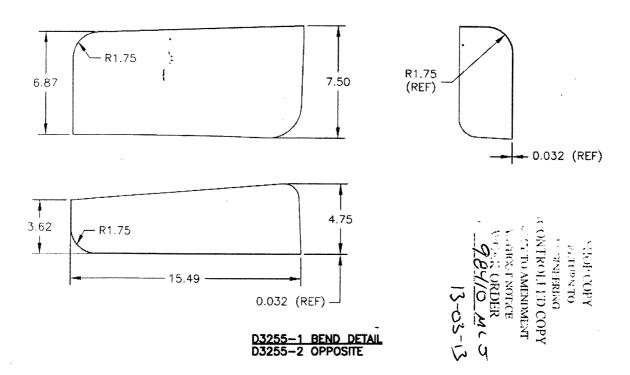
Folio



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	DESIG	N FA	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	CHECH	KED ,	APPROVED	DRAWING NO. REV.	В
		W	<b>₩</b> -	D3255 SHEET 1 OF	4
	DATE			TITLE SCA	LE
	04.1	2.06		ACCESS PANEL ASSEMBLY 1	:6
	Α		04.01.27	NEW ISSUE	
	П		04 12 06	D3255_3 REDESIGN: ADDED #0.008	*******



## D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)

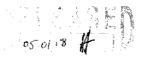


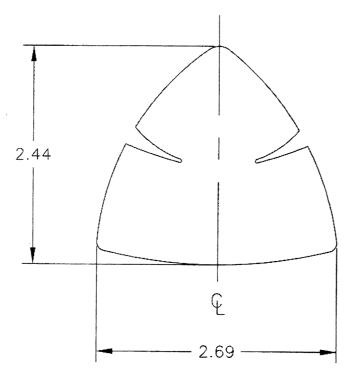
## D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
  3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER



DESIGN	DRAWN BY		ROSPACE LTD , ONTARIO, CANADA
CHECKED (	APPROVED	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE	ii	TITLE	SCALE
04.12.06		TITLE	1:1





D3255-3 CAP FORM TO FIT D3155-1/-2

### D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

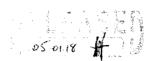
Copyright © 2004 by DART AEROSPACE LTD

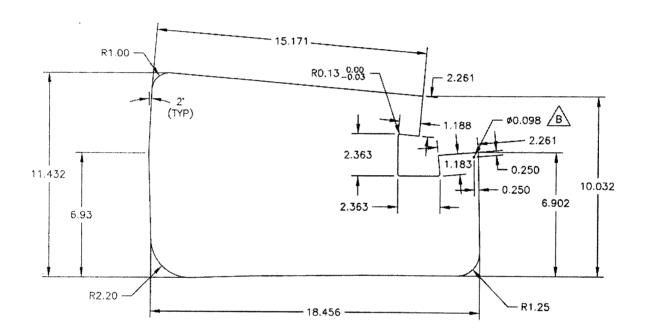
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CHECKED I	APPROVED -	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





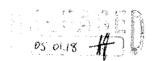
# D3255-1/-2 FLAT PATTERN

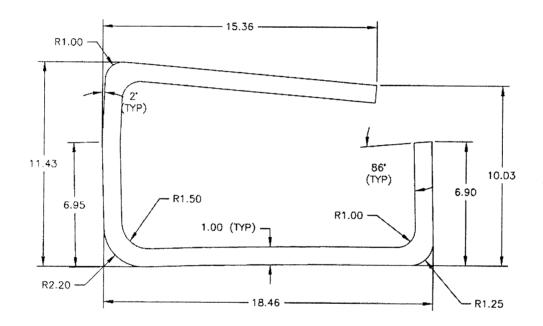
## D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
  2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



DESIGN T	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
91	) IN	D3255	SHEET 4 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





## D3255-5 GASKET

- D3255-5 NOTES:
  1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES